



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.7501

Job Sheet 174308



Part No: 647.7501

Job Qty: 1 ea

Part Name: Lower Cutter Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/13/18

Job Tracking No:

Due Date: 3/14/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A IPP REV:A 12.10.04 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/13/18	0.00	0.00	Start Up Stores/Pkg-1		
110	Packaging	1 pcs		3/13/18	0.00	0.00	Packaging1-1		
120	Small Fab	1 pcs		3/14/18	0.00	1.28	Small Fab-1		
130	QC	1 pcs		3/14/18	0.00	0.00	QC5		
140	Packaging	1 pcs		3/14/18	0.00	0.00	Packaging3-1	000001	
150	QC21-SA	1 Ea		3/14/18	0.00	0.00	QC21		

Part Op 120 - Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

Descriptions: 140 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
646.3015	Blade	2 Ea (2 ea)	90-Start up Operation	5050937 1x 5050835 1x
647.7601	Lower Deflector Assembly	1 Ea (1 ea)	90-Start up Operation	
647.7810	Bracket A	1 Ea (1 ea)	90-Start up Operation	
647.7811	Bracket B	1 Ea (1 ea)	90-Start up Operation	
647.7813	Center Plate, Lower	1 Ea (1 ea)	90-Start up Operation	
647.7814	Fwd Bracket	1 Ea (1 ea)	90-Start up Operation	
647.7815	Fwd Bracket	1 Ea (1 ea)	90-Start up Operation	
647.7816	Aft Bracket	1 Ea (1 ea)	90-Start up Operation	
647.7817	Aft Bracket	1 Ea (1 ea)	90-Start up Operation	
MS21042-08	Use Ms21042L08	13 Ea (13 ea)	90-Start up Operation	
MS21042-3	Nut	3 Ea (3 ea)	90-Start up Operation	
MS27039-08-19	Screw	7 Ea (7 ea)	90-Start up Operation	
MS27039-08-24	Screw (MS27039-0824)	6 Ea (6 ea)	90-Start up Operation	
MS27039-1-19	Screw	3 Ea (3 ea)	90-Start up Operation	
NAS1149F0332P	Washer	6 Ea (6 ea)	90-Start up Operation	
NAS1149FN832P	Washer	26 Ea (26 ea)	90-Start up Operation	

1687

S038952 x1 - 646.3001

1687

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	646.3015	2	13	0
	647.7601	1	5	0
	647.7810	1	5	0
	647.7811	1	9	0
	647.7813	1	7	0
	647.7814 <i>Subassy</i>	1	6	0
	647.7815	1	7	0
	647.7816	1	7	0
	647.7817	1	6	0
	MS21042-08 <i>Subassy</i>	13	0	0
	MS21042-3 <i>Subassy</i>	3	384	0
	MS27039-08-19 <i>27543</i>	7	2,213	0
	MS27039-08-24	6	80	0
	MS27039-1-19 <i>2444d</i>	3	406	0
	NAS1149F0332P <i>20603</i>	6	2,835	0
	NAS1149FN832P <i>20601</i>	26	4,173	0
Part Specifications				
Specifications could not be found.				

Plex 3/13/18 2:01 PM dart.lacelle.linda



Container No: S051322



Part: 647.7501
 Job No: 174308
 Serial No/Batch: S051322
 Revision:
 Inspector:

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K64 1K7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Date: 03/14/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : _____							



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
001639	S051142	647.7601	Lower Deflector Assembly	S044445	CCK065	1
001639	S032291	647.7810	Bracket A	M137968-180	CCK077A	1
001639	S051134	647.7811	Bracket B	S032013	CCK077A	1
001639	F159558	647.7813	Center Plate, Lower		CCK114	1
001639	S051137	647.7814	Fwd Bracket	S030228	CCK114	1
001639	F159548	647.7815	Fwd Bracket		CCK114	1
001639	S051136	647.7816	Aft Bracket	S030948	CCK114	1
001639	S051141	647.7817	Aft Bracket	S031346	CCK114	1
001639	S051159	MS21042L08	Nut	S016879	ST303	13
001639	S051157	MS21042L3	Nut	S038764	ST303	3
001639	S051155	MS27039-08-19	Screw	S027543	ST277	7
001639	S051154	MS27039-1-19	Screw	S024444	ST280	3
001639	S051153	NAS1149F0332P	Washer	S020603	ST262	6
001639	S051151	NAS1149FN832P	Washer	S020604	ST263	26

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 3/14/18 8:55 AM dart.quirion.sonia